

Sept 17/10

Dart Aerospace Ltd.

Date: Thursday, 10/11/2007 2:54:06 PM
User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	STRUT	3					
Job Number	: 35118								
Estimate Number	: 10961								
P.O. Number	:	Part Number	: D2565209						
This Issue	: 10/11/2007	S.O. No.	: D2565 REV E						
Prsht Rev.	: NC		Project Number	: N/A					
First Issue	: / /	Type	: SMALL /MED FAB	Drawing Revision	: E				
Previous Run	: 31246		Material	:					
Written By	:		Due Date	: 10/17/2007	Qty:	10	Um:	Each	
Checked & Approved By	: 07/10/11								
Comment	: Est: 01.06.04 Added Powder Coat, Removed Polish, and Added Inspection Levels 3 & 21EC								
Additional Product									
Job Number:									
Seq. #:	Machine Or Operation:	Description :							
1.0	M304TR0750W049	304 RD Tube .750 x .049W 							
Comment: Qty.: 1.3475 f(s)/Unit Total : 13.4747 f(s) M 102 125 ① Material: 304/316 SS tubing 0.750" Dia. x 0.049" wall (M304TR0750W049) Batch No: M 105354② M 104727④ M 1015									
2.0	BRAKE NC	NC BRAKE 							
Comment: BRAKE NC Punch as per Dwg D2565 using DT 8313 SB 07/10/15									
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 							
Comment: SMALL & MEDIUM FAB RESOURCE 1 SAD 07/10/15 ⑪ Deburr									
4.0	QC5	INSPECT WORK TO CURRENT STEP 							
Comment: INSPECT WORK TO CURRENT STEP En 07/10/15 ⑩ counter,									
5.0	POWDER COATING	POWDER COATING 							
Comment: POWDER COATING M105068 Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3 Hs 07-10-16 ⑪									

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: STRUT

Job Number: 35118

Part Number: D2565209

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

EJost/10/16 ⑩

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

EJost/10/16 ⑪

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

04.10.16 KJ

Job Completion



W 10-16

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

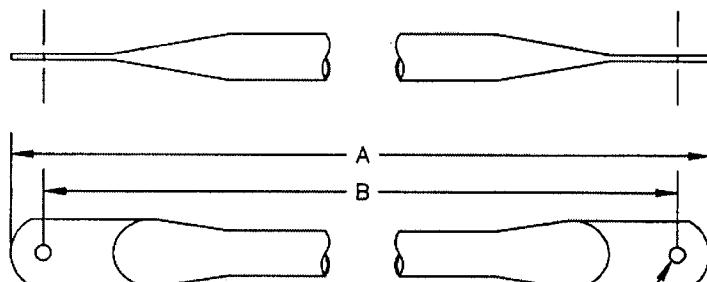
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DARTCOPY/3
DRAFT

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.	REV. E	SHEET 1 OF 1
		D2565		
DATE		TITLE	SCALE	
04.05.05		STRUT		1:3
A	96.05.03	NEW ISSUE		
B	97.03.15	CORRECT D2565-111 DIM. A		
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)		
D	02.06.05	ADD -3XX PARTS; ADD FINISH		
E	04.05.05	ADD D2565-401-411; RMV ANGLE D		

RELEASED
04.05.05

DIA 0.257 TO BE PUNCHED
 "C" DIA TO BE OPENED MANUALLY

PUNCH ENDS PER SPEC CONTROL DRAWING D2638

PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	—
D2565-109	12.31	11.51	—
D2565-111	13.65	12.85	—
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	—
D2565-209	15.16	14.36	—
D2565-211	14.14	13.34	—
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	—
D2565-309	20.17	19.37	—
D2565-311	16.30	15.50	—
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	—
D2565-409	9.34	8.54	—
D2565-411	13.81	13.01	—

GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL
 (REF. DART SPEC. M304TR0.750W0.049)
 ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005
 4) SUBJECT TO AMENDMENT
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
 WITHOUT NOTICE
- 4) ALL DIMENSIONS ARE IN INCHES

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4) SUBJECT TO AMENDMENT

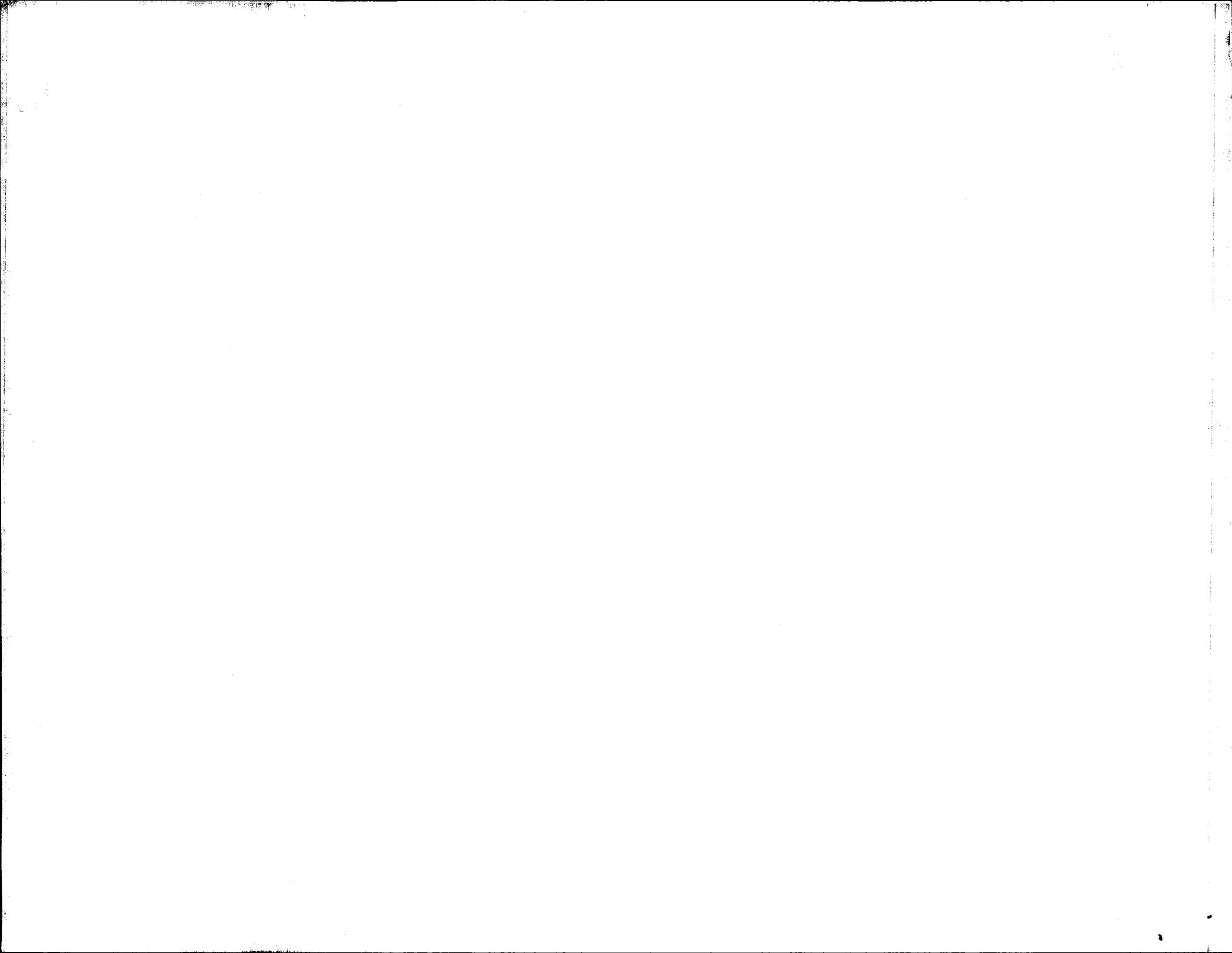
WITHOUT NOTICE

WORK ORDER

NO. 35118

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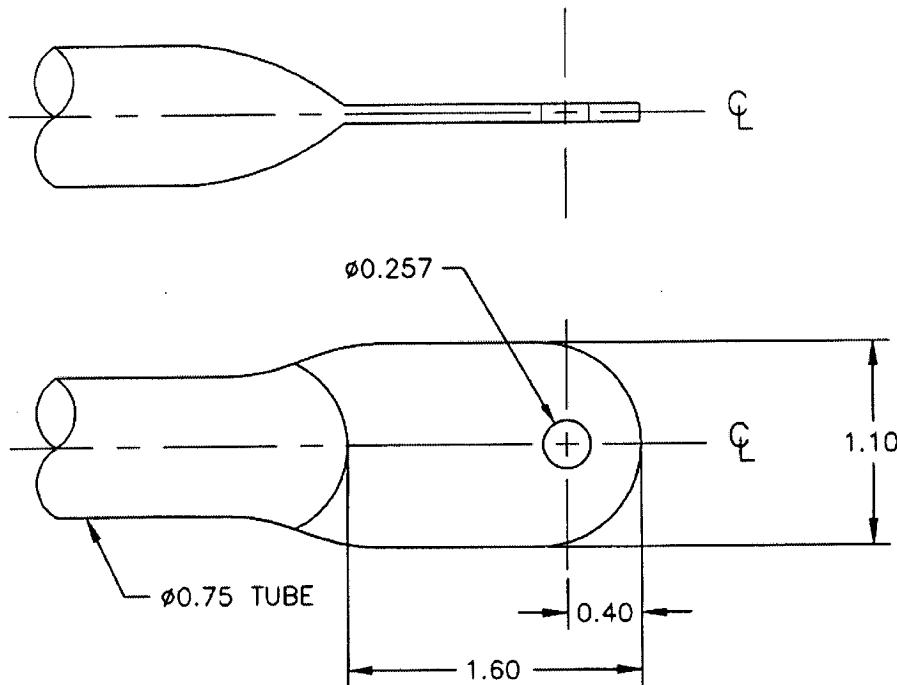


DART

DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MJ</i>	APPROVED <i>JF</i>	DRAWING NO. D2638	REV. A SHEET 1 OF 1
DATE 98.04.28		TITLE PUNCH DT8117 SPEC CONTROL	SCALE 1:1
A	98.04.28	NEW ISSUE	

RELEASED
98/09/05 KE

SPECIFICATION CONTROL DRAWING FOR PUNCH DT8117



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